

Date: Wednesday, 14/05/2008 10:01:43 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 39257		
Estimate Number	: 10707		
P.O. Number	:	Part Number	: D2012105
This Issue	: 14/05/2008 S.O. No. :	Drawing Number	: D2012-105 REV D1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 14/05/2008 Type : SMALL /MED FAB	Drawing Revision	: D1
Previous Run	: 37042	Material	:
Written By	:	Due Date	: 22/05/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JUL 08.5.14</u>		
Comment	: Est Rev: 02.04.03 Added Inspect level 3 NG		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 2.7567 f(s)/Unit Total: 27.5667 f(s)  
 Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)  
 Identify as D2012-101  
 Batch: M107967 SB 08/05/20 (10)

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Punch to length as per Dwg D2012-105 & template D2012-105T1 SB 08/05/20 (10)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Deburr

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP SB 08/05/20 (10)

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 8:00OVEN TEMPERATURE: 320°F M-J 08/05/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 14/05/2008 10:01:43 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 39257

Part Number: D2012105

Job Number:



Seq. #:

Machine Or Operation:

Description :

FINISH TIME:

8:30

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/05/21 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 226

JS 08/05/21 (10)

8.0

QC21

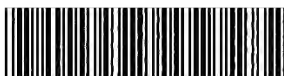
FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/22

Job Completion



umf 08-05-22

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**DART**DART AEROSPACE LTD  
HAMKESBURY, ONTARIO, CANADA

REV. D

DESIGN/  
CHECKED *MM*DRAWN BY  
*KE*

DRAWING NO.

D2012-105

SHEET 1 OF 1

DATE

98.04.28

TITLE

ARM

SCALE

NTS

A

92.06.04

NEW ISSUE - DRAWN FROM D2012

B

96.06.25

30° ANGLE ROTATED 60° CCW

C

97.09.03

CORRECTED VIEWS PER TSR A374

D

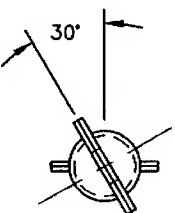
98.04.28

ADDED TEMPLATE & SPEC CTRL DWG  
REDRAWN IN CAD

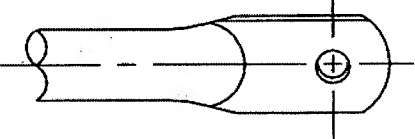
D1

~~92.03.25~~

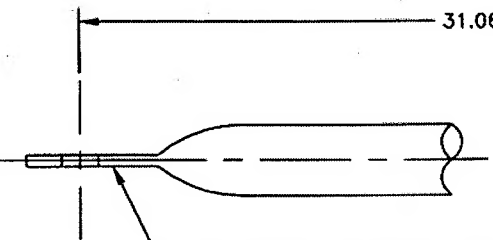
ADD FINISH

**RELEASED**  
48/05/05 KE

3



31.06

PUNCH BOTH ENDS PER SPEC  
CONTROL DRAWING D2727

## NOTES:

1. MAKE PER TEMPLATE DT8116 (WAS D2012-105)
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.500 x 0.035 WALL
3. FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART. QSI 005 4.3

SHOP COPY  
RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 37257

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries